



Commodity Specification

SMOKED TURKEY HAM

MAY 2002



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I. GENERAL

Frozen smoked turkey hams (hams/commodity) produced under this Specification will be packaged and packed in the following form as specified in the contract:

Smoked Turkey Ham (234040) - Frozen smoked turkey hams produced from nonbasted, young ready-to-cook turkey thigh meat. Hams must weigh not less than 9 pounds (4.08 kg) and not more than 11 pounds (4.99 kg), be vacuum packaged in shrinkable oxygen- and moisture-proof bags or casings, and be packed four hams per fiberboard shipping container. A purchase unit will total 40,000 pounds (18,144 kg).

II. COMMODITY SPECIFICATION

A. Basic Requirements

1. Date Processed. The commodity must not be processed prior to the date of the contract.

2. Origin of Turkeys. The commodity must be produced and processed from young turkeys which were produced, raised, and processed in the United States, its territories or possessions, the Commonwealth of Puerto Rico, or the Trust Territories of the Pacific Islands. If the contractor processes or handles turkey products originating from sources other than the United States, its territories or possessions, Puerto Rico, or the Trust Territories of the Pacific Islands, the contractor must have an acceptable identification and segregation plan for those turkey products to ensure they are not used in the commodities produced under this Specification. This plan must be made available to a representative of the Grading Branch, Poultry Programs, AMS, USDA (grader), and the Contracting Officer or agent thereof upon request. **The contractor must ensure that both the contractor and subcontractor(s) maintain records such as invoices, or production and inventory records evidencing product origin, and make such records available for review by the USDA grader or other Government official(s) in accordance with Article 76 of USDA-1.**

3. Inspection. Processing operations must comply with Poultry Products Inspection Regulations (9 C.F.R. part 381) and be under the supervision of a representative of USDA's Food Safety and Inspection Service (FSIS) (inspector). Inspection for contract and Specification compliance will be in accordance with the Regulations Governing the Voluntary Grading of Poultry Products and Rabbit Products (7 C.F.R. part 70) and the U.S. Classes, Standards, and Grades (AMS 70.200 *et seq.*) under the supervision of a USDA grader. The USDA grader will be responsible for certification of compliance with the requirements of this Specification for ready-to-cook turkey products; preparation, formulation, and fabrication of turkey hams; smoking, cooking, and cooling turkey hams; packaging and packing; freezing; labeling and marking; sampling; net weight; and checkloading.

II.A.

4. FSIS Requirements. The commodity must be produced and processed in an FSIS Federally inspected establishment, be accurately marked and/or labeled, and meet all FSIS regulatory requirements, including all microbiological testing requirements, currently in place.

5. Product Temperature. Temperature of the products, unless otherwise specified, must comply with FSIS regulations (9 C.F.R. § 381.66), FSIS directives and guidelines for cooked products, and this Specification throughout all operations including transportation between plants.

6. USDA Sampling Option. USDA may select additional product for further inspection or may draw samples for laboratory analyses.

7. Definition of a Lot. A lot is the amount of packaged commodity produced during a processing shift.

B. Meat and Skin

1. Sources of Meat.

a. Smoked turkey hams must be produced from boneless skinless turkey thigh meat. Thigh meat (meat) must be from nonbasted, young ready-to-cook turkeys (no solution or ingredients added) (AMS § 70.202). The chilled turkey thighs must be deboned and used in the turkey ham within 7 calendar days after the day the turkeys are slaughtered.

b. Chilled thighs from frozen turkeys may be used when the frozen turkeys: (1) have been packaged to protect them from freezer burn and dehydration during storage, and (2) have not been held more than 180 days in frozen storage and have been identified so the class of turkey can be determined. The resultant boneless skinless thighs must be processed (without refreezing) into the hams within 48 hours from the time of deboning.

c. Frozen thighs may be used when: (1) produced from freshly slaughtered turkeys, (2) packaged to protect against quality deterioration during storage and identified so the time in storage and the class, kind, and specific deboned turkey product can be determined, and (3) held not more than 60 days in frozen storage. After thawing, the thighs must be used in the production of turkey hams within 48 hours.

d. Turkey thigh meat trimmings that are removed from the turkey thighs during the boning and trimming process may be used if they represent no more than 15 percent of the total weight of the turkey thigh meat as specified in the formulation section (II.C.4.).

2. Turkey Products From Other Plants. Turkeys, turkey thighs, and boneless skinless turkey thighs may be transferred or obtained from other processing plants to produce hams, provided they: (a) have been processed, handled, and identified in accordance with this Specification, and (b) comply with the organoleptic, nonbasted, and other applicable requirements for turkey products to be used in hams as evidenced by USDA certification.

a. Type, class, and specific name of the product; part or boneless part; date slaughtered, or date placed in frozen storage, as applicable; and the USDA-assigned plant number must be shown on each shipping container.

b. The chilled and/or frozen turkey products must be at an internal product temperature not higher than 40°F (4.4°C) when shipped from the origin plant and when received at the destination plant.

3. Requirements for Meat and Skin.

a. Meat. The meat used to produce smoked turkey hams must comply with the following:

(1) Thighs. Meat must be derived from skinless turkey thighs. Thighs must be in recognizable portions; that is, complete thighs, or thighs with no more than one-half of the meat missing.

(2) Optional - thigh trimmings. As an optional ingredient, 15 percent of the meat portion of the formula may be turkey thigh trimmings as provided in II.B.1.d.

b. Unacceptable meat. Mechanically separated turkey (comminuted) cannot be used.

c. Skin. All skin must be removed from each thigh.

d. Maximum temperature. The temperature of the meat must not exceed 55 °F (12.8 °C) at any time during preparation or processing of these turkey products into turkey ham.

e. Cooling requirements. Skinless thighs and thigh trimmings, which are not used in the turkey ham on a continuous basis, must be cooled by cooling methods/media that ensure that the internal product temperature is continuously lowered to 40 °F (4.4 °C) or lower.

f. Cooling medium.

(1) Cooling methods and media (e.g., use of carbon dioxide (CO₂) or liquid nitrogen (N₂)) may be used to maintain the temperature of meat.

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(2) Containers of boneless skinless thighs and thigh meat must not contain added water (e.g., water from ice or slush ice and water). Liquid associated with normal product weepage is acceptable.

g. Organoleptic requirements. Boneless skinless thighs and thigh trim will be examined on a continuous basis for organoleptic requirements shown in Table 1 below. Any product that does not comply with the organoleptic requirements will be rejected for use under this Specification.

h. Meat defects. Boneless skinless thighs and thigh trim will be examined for defects on a sampling interval basis.

(1) A sample of 30 pieces of boneless skinless thighs and 2 pounds (0.91 kg) of thigh trim (as applicable) will be drawn and examined for the defects, shown in Table 1, before it is used in the formula. The frequency of sampling and the number of defects allowed will be those outlined in the Poultry Programs' Sample Plan Level 1 (SPL-1) for boneless thighs; and Sample Plan Level 2 (SPL-2) for thigh trim. Separate examinations will be made for: (a) bone and (b) other defects.

(2) Thigh trim that is size-reduced using equipment described in II.C.1.b.(2), shall be examined for bone, bone-like material, cartilage (gristle), cartilage-like material, or hard tendons or tendinous material *after size reduction only*. Regardless of the size-reduction system used, thigh trim will be examined for skin, blood clots, and discolorations prior to size reduction.

(3) Regardless of the kind and number of defects (within Table 1) found, any sample with bone or bone-like material greater than 0.50 inch (1.27 cm) will be cause for the rejection of the product the sample represents.

(4) If the number of bone defects exceed the maximum for the "target" level, or results in a rejection, the frequency of sampling for bone defects will be increased to 30 pieces of boneless skinless thighs and/or 2 pounds (0.91 kg) of thigh trim (as applicable) drawn twice each sampling interval until the cumulative number of bone defects reverts back to the "target" level.

(5) If the sample has more defects than the maximum tolerance for the sample plan, the product the sample represents will be rejected.

Table 1. Organoleptic Requirements and Defects for Meat

Organoleptic Requirements:	Meat must: (a) not be rancid; have a fruity, sulfide-like, cardboardy, tallowy, oily, metallic, chlorine-like, or other foreign or off-odors; contain foreign materials (e.g., glass, paper, rubber, metal); and have a bright color; and (b) not show evidence of mishandling or deterioration; or dehydration or freezer burn or thawing and refreezing.
Boneless Meat and Trim Defects:	
Bone:	<p>Bone or bone-like material greater than 0.50 inch (1.27 cm). See II.B.3.h.(3).</p> <p>Bone or bone-like material less than or equal to 0.50 inch (1.27 cm).</p>
Other:	<p>Cartilage (gristle), hard tendons or tendinous material (except as provided in II.C.1.b.), or blood clots (thigh meat only).</p> <p>Skin exceeding an aggregate area equivalent to the area of a circle with a diameter of 0.50 inch (1.27 cm).</p> <p>Moderate discolorations exceeding an area equivalent to the area of a circle with a diameter of 0.50 inch (1.27 cm).</p> <p>Lightly shaded discolorations exceeding an area equivalent to the area of a circle with a diameter of 1 inch (2.54 cm). Slight discolorations are permitted, provided the discoloration does not detract from the overall appearance of the meat.</p>
Additional - Pertaining to Trim Meat:	Blood clots exceeding an area equivalent to the area of a circle with a diameter of 0.25 inch (0.64 cm).
Boneless Thighs:	Thigh with more than one-half of the meat missing.

C. Processing1. Size Reduction.

a. Thigh meat. Thigh meat must be reduced in size through a plate with openings that are not less than 0.50 inch (1.27 cm) and not greater than 1.00 inch (2.54 cm).

b. Trim meat.

(1) Thigh trimmings must be ground through a plate with holes no less than 0.125 inch (1/8 inch) (3.175 mm) in diameter; or reduced through a desinewer plate or screen with holes 0.0591 inch to 0.0787 inch (1.50 mm to 2 mm) in diameter. For trim meat reduced through a desinewer plate or screen, the patella (knee cap) and portions of the condyle of the femur may be present when attached to the thigh trim.

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(2) Additionally, the plate, screen, or equipment may be designed to extract, and discharge bone, bone-like material, cartilage, etc., simultaneously with size-reduction. The system must provide a continuous flow of discharge material during size-reduction. The discharge material may be collected and used in accordance with FSIS policy, but must not be used in the commodity produced under this Specification.

c. Other methods. The meat may be reduced to an equivalent size by other methods reviewed and found acceptable by supervisory personnel of the Grading Branch, Poultry Programs.

2. Requirements for Size-Reduced Meat.

a. Organoleptic requirements and defects for trim meat.

(1) The size-reduced trim meat will be examined in the fresh state on a continuous basis for the organoleptic requirements listed in Table 2 below prior to formulation. If the product does not comply with the organoleptic requirements it will be rejected for use under this Specification.

(2) When an extraction/collection system is used in conjunction with size reduction (see II.C.1.b.(2)), a 2-pound (0.91-kg) sample of size-reduced trim meat will be drawn and examined in the fresh state for the defects listed in Table 2 below prior to formulation.

Table 2. Organoleptic Requirements and Defects for Size-Reduced Trim Meat

Organoleptic Requirements:	Meat must: (a) not be rancid; have a fruity, sulfide-like, cardboardy, tallowy, oily, metallic, chlorine, or other foreign and off-odors; contain foreign materials (e.g., glass, paper, rubber, metal); or show evidence of mishandling or deterioration; and (b) have a bright color.
Trim Meat Defects:	The sample must be free of bone or bone-like material.
	Cartilage (gristle) or cartilage-like material, or hard tendons or tendinous material.

(3) If the sample of size-reduced trim meat contains bone or bone-like material, or has more trim meat defects (listed in Table 2 above) than the maximum tolerance for SPL-2, the product the sample represents will be rejected for use under this Specification.

b. Temperature requirements. Size-reduced meat and trim which is not used in the turkey ham on a continuous basis, must be cooled by using cooling methods or media (e.g., use of CO₂ or N₂) that ensure that the internal product temperature is lowered to not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C). Water, refrigerated water,

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slush ice and water, or ice used to cool or maintain the temperature of meat or trim must not be incorporated into the size-reduced product. Liquid associated with normal product weepage is acceptable. No frozen or previously frozen size-reduced meat or trim may be used in the turkey hams.

3. Processing Sequence. Unless otherwise specified, the size reduction, formulation, mixing, stuffing into casings, smoking/cooking, cooling, packaging and packing, and freezing of the commodity must be a continuous process that complies with the time and temperature requirements of this Specification.

4. Formulation.

a. Proportions of ingredients required in preparing smoked turkey hams are as follows:

	<u>Percent of Total by Weight</u>
Size-Reduced Thigh Meat	95.00 (minimum)
Optional - Thigh Trimmings (up to 15% of the meat portion)	
Other Ingredients:	
Salt	2.00
Sugar	2.00
Sodium Phosphate	0.50
Sodium Erythorbate or Sodium Ascorbate	468.00 PPM
Sodium Nitrite	156.00 PPM

(1) Sugar may be sucrose, brown sugar, dextrose, or a combination thereof.

(2) Amount and kind of sugar, phosphate, cure, and cure accelerator must be in accordance with FSIS regulations (9 C.F.R. § 424.21(c)).

(3) Water and/or ice must be added to assist in the processing of turkey hams. The amount of water/ice and other ingredients must comply with the 15 percent water added statement for the finished turkey ham, and comply with FSIS requirements.

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(4) Dry ingredients may be mixed with water to form a brine solution prior to the addition of the meat. As an option to forming a brine solution, dry ingredients may be added directly to the meat portion and thoroughly mixed (also see II.C.5.).

(5) If liquid smoke flavoring is added to the formulation, the percentages for salt, sugar, and phosphate may be adjusted (reduced) to include this ingredient.

(6) Verification of compliance with actual percentages of sodium erythorbate or sodium ascorbate and sodium nitrite used will be monitored by FSIS personnel in accordance with FSIS procedures.

(7) An example formulation is provided in EXHIBIT 1 “Example Formulation For Smoked Turkey Hams.” Actual formulation calculation and ingredient poundage is dependant on the amount of water, smoking/cooking methods, and yield percentages used and determined by individual contractors/processors. The example formulation in EXHIBIT 1 is only an example and should not be mistaken for actual poundage to be used.

b. Batches of turkey thigh meat, trimmings, and other ingredients must be formulated to comply with the required 95 percent fat free labeling. Verification will be monitored by FSIS personnel in accordance with FSIS labeling requirements and procedures.

c. No binders or extenders are allowed. Processing aids (e.g., anti-caking agents, anti-dusting agents, or other manufacturing aids) are allowed if used and labeled in accordance with FSIS requirements. If processing agents are used, the ingredients and amount of ingredients listed in the formulation (II.C.4.) must remain the same.

d. Formulated batches of ingredients which do not comply with II.C.4.a., b., and c. above will be rejected.

5. Mixing. The brine solution must be incorporated into the size-reduced thigh meat by mixing/blending, or tumbling or massaging with or without vacuum. If the option of adding dry ingredients directly with the meat portion is used, batches of meat, dry ingredients, and water/ice must be thoroughly mixed (by mixing/blending, or tumbling or massaging with or without vacuum) to ensure even distribution of ingredients throughout the batch.

6. Stuffing into Casings.

a. After blending, the formulated batches of ingredients must be stuffed into smoke impregnated or standard fibrous casings which are round in shape.

b. Formulated batches of ingredients must be stuffed into casings which conform to the finished smoked ham commodity requirements of 4 to 5 inches (10.16 to 12.70 cm) in diameter and 9 pounds (4.08 kg) to 11 pounds (4.99 kg) net weight.

c. In no case will the stuffing of the formulated batches of ingredients into casings be delayed longer than 48 hours or be held at a room temperature higher than 40 °F (4.4 °C) or lower than 26 °F (-3.3 °C).

7. Smoking.

a. Requirements. Stuffed casings of formulated product must be smoked in accordance with approved FSIS procedures. The type and amount of liquid smoke flavoring and the smoke ingredients used for smoke impregnated fibrous casings must be in compliance with FSIS regulations and this Specification.

b. Labeling of smoked products.

(1) Product smoked in compliance with FSIS policies and procedures (i.e., naturally smoked, smoked by transforming into gaseous state or vapor, or smoked impregnated casings) shall be labeled in accordance with the section III.C.4.a.(1).

(2) Product smoked in compliance with FSIS policies and procedures (i.e., smoke incorporated into product as an ingredient) shall be labeled in accordance with section III.C.4.a.(2). The smoke flavoring must be listed in the ingredients statement.

8. Cooking. The turkey hams must comply with FSIS cooking regulations (9 C.F.R. § 381.150). The turkey hams must be smoked/cooked to an internal product temperature of 155 °F (68.3 °C) or higher. Cooking methods and product temperature will be monitored by FSIS personnel in accordance with FSIS procedures.

9. Cooling. After cooking, the hams must be cooled to an internal product temperature of 40 °F (4.4 °C) or lower. Cooling methods and procedures must be in compliance with FSIS directives and guidelines for cooked products.

10. Packaging and Packing Materials. All packaging and packing materials must comply with the requirements of this Specification, be clean and in new condition, and must not impart objectionable odors or flavors to the product.

a. Bags and casings.

(1) Packaging materials--bags and casings--must be safe (cannot adulterate product or be injurious to health) for use in contact with food products. The safety of food-contact packaging materials will be in accordance with 9 C.F.R. § 381.144.

(2) Bags or casings for packaging smoked turkey hams must be made of water-proof film with oxygen barrier properties. Bags and casings must be heat-shrinkable, and have: (a) low-temperature flexibility (not brittle) and durability to resist stress-cracking

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caused by the temperatures of freezing and frozen storage, and (b) the impact and tensile strength, and tear and abrasion resistance to protect the product from dehydration, freezer burn, quality deterioration or contamination during the conditions of use. Any seams in the bag or casing must provide the protective qualities equivalent to the body of the bag or casing.

b. Shipping containers.

(1) Requirements. Shipping containers must: (a) be a fiberboard container; (b) be of such size to pack the commodity without slack filling or bulging; (c) protect the commodity against loss and damage; (d) withstand the variations in humidity and temperature during the conditions of use; and (e) have the combined facings weight and the compression strength (edge crush value) to withstand the stresses of handling, shipping, stacking, and storage.

(2) Container Bottom. Flaps on the bottom of a shipping container must be securely fastened so the bottom remains securely fastened when the top of the container is opened.

(3) Final Closure. Final closure of the shipping containers must be secure and made with commercially acceptable filament-reinforced tape, plastic-film packaging tape, non-metallic strapping, adhesive, or other similar types of materials that are applicable for cold temperature storage conditions and that provide for safe handling of the commodity. Steel or wire straps must not be used for the final closure. Staples must not be used for the final closing of shipping containers. However, staples may be used to manufacture and to assemble the shipping containers, provided the staples are fastened into the container and tightly clenched to eliminate sharp edges prior to packing the commodity into the shipping containers.

11. Packaging and Packing.

a. Packaging. After the smoking, cooking, and cooling processes, the fibrous casing must be removed from the turkey hams just prior to packaging. Turkey hams must be packaged in a heat shrinkable oxygen- and water-proof bag or casing (as described in II.C.10.a.).

(1) The excess air must be removed (by vacuum) from each bag or casing. The bag or casing must be shrunk to fit tightly against the surface of the hams.

(2) After the air is removed, the bags or casings must be hermetically heat sealed to ensure a vacuum closure and to prevent product dehydration and quality deterioration. Metal wire ties, paper-coated wire ties, or staples must not be used for sealing bags or casings.

b. Packing. Four packaged hams must be packed in each shipping container.

12. Freezing. Packaged smoked turkey hams must be placed in a freezer within 24 hours of packaging and must be frozen by lowering the internal product temperature to 0 EF (-17.8 EC) or lower within 72 hours from the time of entering the freezer. If the packaged hams are not placed in a freezer immediately after packaging, the hams must be held at a room temperature not higher than 36 EF (2.2 EC) and not lower than 26 EF (-3.3 EC) for no longer than 48 hours. When packaged hams are held at a room temperature below 26 EF (-3.3 EC), the turkeys will be considered to be in a freezer and subject to the 72-hour freezing requirement which begins when the hams enter the freezer.

D. Metal Detection

1. Requirements.

- a. Each fabricated turkey ham must be examined by a metal detection device capable of detecting metallic contaminants including, but not limited to, stainless steel shavings, metal clips, metal fragments from cutting equipment, and pieces of wire.
- b. The commodity must be presented correctly within the detection field pattern of the device. Procedures used must be appropriate for the dimensions, location, and pattern of the detection field, the "orientation effect" on the sensitivity of the device, the environmental conditions, and the commodity.

2. Operating Efficiency and Procedures. The operating efficiency of the metal detection device will be determined hourly by the USDA grader by placing a detection test strip with a sphere of 440 stainless steel in the center of the detection field pattern. Poultry Programs will provide the detection test strip with the stainless steel sphere of the specified diameter.

- a. Turkey hams must be examined prior to or after placing hams in the bag or casing. As an alternate method, the formulated ham product may be examined by an in-line metal detection device installed in the mechanical stuffing or forming system before smoking and cooking. If the alternate metal detection method (in-line) is used and casings are later cut to meet the physical requirements in II.E.3., hams must also be examined by a metal detection device prior to or after placing hams in the bag or casing.
- b. The USDA grader will use a detection test strip with a 3.00 mm (0.1181 inch) sphere for the examination of: (1) packaged hams, (2) packaged hams in a shipping container, or (3) the formulated ham product in an in-line system, as applicable, for the detection system.
- c. As an alternate test method for an in-line detection device, a detection test strip with a 1.50 mm (0.0591 inch) sphere may be placed in the detection field outside and adjacent to the device carrying the formulated product.

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3. Contaminated Product. These guidelines do not relieve the contractor of the responsibility to provide a safe product. Product found to be contaminated with metal will be handled in accordance with FSIS procedures.

4. Other Detection Procedures. Other procedures for examination of the commodity must be approved by the Deputy Administrator of Poultry Programs, in writing.

E. Finished Smoked Turkey Ham Requirements

1. Skin. No skin must be used in the smoked turkey hams.

2. Fabrication. Turkey hams must be fabricated, packaged, and packed so they can be hand-sliced or sliced by a meat slicer with minimal separation.

3. Physical Requirements. Packaged smoked turkey hams must (a) be 4 to 5 inches (10.16 to 12.70 cm) and round in diameter, and (b) weigh 9 to 11 pounds (4.08 to 4.99 kg) each.

4. Water Added Statement. The finished smoked turkey ham must be formulated with water and other ingredients in a manner that complies with the required labeling of "15 percent water" added for each ham.

5. Percent Fat Free Statement. The finished smoked turkey ham must be formulated to comply with the requirements of this Specification, and comply with the "95 Percent Fat Free" statement to be placed on each shipping container. The contractor/processor is responsible for providing any analysis data required by FSIS to label this commodity.

6. Defects. Finished hams will be examined for the organoleptic requirements and defects shown in Table 3 below prior to freezing. A USDA grader will examine two hams each sampling interval for exterior defects. Each sample ham will then be sliced into two approximately equal portions exposing a total of four interior surfaces that will be examined for interior defects. The frequency of sampling and the number of defects allowed will be those outlined in Poultry Programs' SPL-2 found in the Poultry Graders Handbook. Examination for the defects shown in Table 3 will be made separately.

a. Any product that does not comply with the organoleptic requirements will be rejected for use under this Specification.

b. The color of the hams must be a uniform mahogany color that is no lighter than the "light tolerance" or darker than the "dark tolerance" shown in the color control guidelines for smoked turkey ham examples prepared by Poultry Programs, dated July 1994 (provided by Poultry Programs to plants with a contract).

c. If the sample has more interior and/or exterior defects than the maximum tolerance for sample plan, the product the sample represents will be rejected and may be reworked in accordance with II.E.7.

Table 3. Organoleptic Requirements and Defects for Turkey Hams

Organoleptic Requirements:	Ham must not: Be rancid; have a sour, stale, fruity, sulfide-like, cardboardy, tallowy, oily, oxidized, metallic, acidic, or other off or foreign odors; contain foreign materials (e.g., glass, paper, rubber, metal); or have foreign flavors such as, but not limited to, burnt, scorched, or stale.
Exterior Defects:	<p>The exterior of finished ham contains individual major surface voids (including air voids, fat pockets, and purge pockets) exceeding an aggregate area equivalent to the area of a circle with the diameter 0.75 inch (1.91 cm). The depth of a void or pocket must be no greater than 0.50 inch (1.27 cm).</p> <p>Unobtrusive purge is allowed; however, pocket and voids holding purge, fat, or air must not exceed the aggregate diameter of 0.75 inch (1.91 cm).</p> <p>The hams show evidence of excessive heating (darkened or scorched).</p>
Color Defects:	An individual ham which does not have a mahogany color associated with smoked meats, or one with a mahogany color lighter than or darker than the tolerance.
Interior Defects: Hams will be cut (widthwise) in two approximate equal pieces.	The interior of ham contains: Voids, gelatin or fat pockets on the sliced surfaces which exceed an aggregate area per surface equivalent to the area of a circle with the diameter 0.75 inch (1.91 cm).

7. Reworked Turkey Hams. Smoked turkey hams which are fractured (separated into two or more pieces); misshaped; have cuts; more internal or external defects than the maximum tolerances allowed; or do not meet the size and weight requirements may be reworked (defects removed) and incorporated into formulated batches of turkey ham provided:

- a. The temperature of the turkey hams has not exceeded an internal product temperature of 40 °F (4.4 °C) and they have been maintained at that temperature or lower;
- b. The hams are reworked within 72 hours from the end of the shift they were packaged;
- c. The hams are ground through a plate with holes 0.125 inch (1/8 inch) (3.175 mm) in diameter;

II.E.7.

d. The hams are incorporated at a maximum of 2 percent of the formulated batch (2 percent of the total 15 percent trimmings allowed); and

e. The hams are added to formulated product which will undergo the same smoking method(s).

III. LABELING

USDA labeling (III.A.-D. and III.F.-G.) or commercial labeling (III.E.-G.) must be used. When USDA or commercial labeling is selected, both the packages and shipping containers within a purchase unit must be labeled in that format. THE CONTRACTOR MUST USE THE SAME LABEL FORMAT (EITHER USDA OR COMMERCIAL) WITHIN A PURCHASE UNIT.

A. USDA Labeling Requirements

When USDA labeling is used, any deviations from the USDA labeling requirements herein in this Specification must be approved by the Contracting Officer, in writing, prior to start of production.

1. Labeling Provisions. Labeling and marking of the product must be in accordance with this Specification. The name, address, and phone number of the manufacturer must appear on each shipping container.

2. Printing Requirements. Labeling and marking information must be water-fast, nonsmearing, of a contrasting color, clear, and readable.

B. USDA Labeled Packages

1. USDA Plant Number. The USDA-assigned plant number must be shown on each bag or casing in legible form.

2. Production Date. The date of production (month, day, and year) must be shown on the bag or casing of each ham.

C. USDA Labeled Shipping Containers

1. Recycle Symbol and Statement. The contractor shall place somewhere on the surface of each recyclable shipping container the recycle symbol shown in EXHIBIT 2. The statement "PLEASE RECYCLE" is to be placed under the symbol. The recycle symbol and statement must be legibly printed in permanent ink.

2. Labeling and Marking Information.

a. Requirements. Labeling and marking information must be: (1) preprinted, stamped, or stenciled on each shipping containers; or (2) printed on a pressure-sensitive label and applied to each shipping container. This information, in essentially the same layout, is provided in EXHIBITS 3 - 5.

(1) Hams smoked in compliance with the methods described in II.C.7.a. and b.(1), shall be labeled in accordance with EXHIBIT 3, "USDA Labeled Shipping Containers" and EXHIBIT 4 "USDA Label Information For Commodity Smoked In Accordance With II.C.7.b.(1)" (naturally smoked, smoked by transforming into gaseous state or vapor, or smoked impregnated casings) (see page 9).

(2) Hams smoked in compliance with the methods described in II.C.7.a. and b.(2), shall be labeled in accordance with EXHIBIT 3, "USDA Labeled Shipping Containers" and EXHIBIT 5 "USDA Label Information For Commodity Smoked In Accordance With II.C.7.b.(2)" (smoke incorporated into product as an ingredient) (see page 9).

b. "END" and "SIDE" designations. For the purpose of labeling and marking, the "end" and "side" panels may relate to the shortest and longest dimensions of the shipping container at the discretion of the contractor/processor. However, the panels must alternate between "end" panel and "side" panel designation with the two side panels and two end panels being located on opposite panels of the shipping container.

3. TOP PANEL - Labeling and Marking. The following information is required (as applicable) on the top panel of each shipping container:

a. Storing instructions. The following storing instructions must be printed on the top panel of the shipping container:

PERISHABLE--KEEP FROZEN
KEEP AT ZERO DEGREE F (-17.8 EC) OR BELOW

b. USDA symbol and manufacturer identification. The following must be printed on the "top panel" or the "one end" designated panel of each shipping container:

(1) The USDA symbol, copy on back of Specification, is to be a minimum of 2.25 inches (5.72 cm) in height.

(2) The manufacturer's name, address, and phone number.

4. ONE END Panel - Labeling and Marking. The following information (as applicable) must appear on one end of the shipping container:

III.C.4.

a. Type, name, qualifying statement, percent fat free statement, and ingredients.

The following is required, and the qualifying statement must be printed in accordance with FSIS regulations (not less than one-half of the size of the product name, but not less than one-eighth inch in height):

(1) For turkey ham, smoked in accordance with II.C.7.a. and b.(1) (see page 9):

FROZEN FULLY COOKED
SMOKED TURKEY HAM * with 15 % Water
* Cured Turkey Thigh Meat, Chunked and Formed
95% FAT FREE

Ingredients:

(2) For turkey ham, smoked in accordance with II.C.7.a. and b.(2) (see page 9).

The smoke flavoring must be listed in the ingredients statement:

FROZEN FULLY COOKED
SMOKED TURKEY HAM * with 15 % Water
* Cured Turkey Thigh Meat, Chunked and Formed, Smoke Flavor Added
95% FAT FREE

Ingredients:

(3) The asterisks (*) must appear on each shipping container (as shown above) beside the product name and qualifying statement.

(4) The ingredients statement must follow the commodity type, product name, and qualifying statement. Ingredients must be listed by proper name and order in accordance with FSIS regulations (9 C.F.R. § 381.118).

b. Inspection mark and plant number. USDA inspection mark and USDA-assigned plant number must be printed on the “one end” designated panel of each shipping container.

c. Storing instructions. The following storing instructions must be printed on the “one end” designated panel of each shipping container:

KEEP FROZEN

d. Net weight. The following net weight statement must be completed and printed on the “one end” designated panel of each shipping container:

4 Hams Net Weight ____ LBS. (____ KG)

e. Nutritional labeling. A nutritional label, indicating the nutrient content of the commodity, is required on the “one end” designated panel of each shipping container. This nutritional facts information or “nutrition facts panel” must be in compliance with the FSIS nutritional labeling requirements.

(1) The contractor/processor must select one of the following methods of providing the nutrition facts panel:

(a) Preprinted on the “one end” designated panel of each shipping container; or

(b) Printed on a pressure-sensitive label and applied to the “one end” designated panel of each shipping container. The pressure-sensitive label must not cover or conflict with the labeling requirements of this Specification.

(2) NOTE: The nutrition facts information and panel must be approved per FSIS regulations prior to shipment of the commodity. The method of providing and location of this information for each shipping container (preprinted or pressure-sensitive label) must be indicated on the FSIS label application.

f. Contract number and pack date. The following information must be printed each shipping containers:

(1) The last five digits of the contract number as it appears in the acceptance wire.

(2) Date packed (month, day, year).

g. Universal product bar code.

(1) A Universal Product Code (UPC), symbol and code, called Interleaved 2 of 5 (I 2/5), must appear on each shipping container. The complete code, including the check digit, must be printed in machine-readable and human-readable form. The start and stop indicators will be included in the bar codes. Printing, readability, and scanability of the bar code must be in accordance with UPC guidelines published by Uniform Code Council, Inc., 7887 Washington Village Drive, Suite 300, Dayton, Ohio 45459.

(2) The contractor will use the code furnished by USDA. USDA has acquired a unique manufacturer’s identification number for the commodity purchase programs and will use a unique item code number for turkey hams purchased under this Specification. The contractors need not join Uniform Code Council, Inc.

(3) The 14-digit UPC code for turkey hams is: 1 07 15001 01548 5

III.C.4.

(4) The UPC code must be placed in the lower right-hand corner of the “one end” designated panel of each shipping container.

h. USDA symbol and manufacturer identification. The following must be printed on the “one end” or the “top panel” designated panel of each shipping container:

(1) The USDA symbol, copy on back of Specification, is to be a minimum of 2.25 inches (5.72 cm) in height.

(2) The manufacturer’s name, address, and phone number.

5. ONE SIDE Panel - Labeling and Marking. No labeling information is required on the side panel immediately to the right of the “one end” designated panel.

6. THE OTHER END Panel - Labeling and Marking. No labeling information is required on the end opposite the panel designated “one end.”

7. THE OTHER SIDE Panel - Labeling and Marking. No labeling information is required on the side opposite the panel designated “one side.”

8. Inventory Control Label. The processor may use a pressure-sensitive label to place any additional information (including bar codes) for processor inventory control purposes. This label may be applied somewhere on the surface of the shipping container. The label must not cover or conflict with the labeling requirements of this Specification.

D. Use of Previously Printed USDA Labeling Materials

Carryover inventories of existing supplies of printed packing materials (USDA labeling) from the Commodity Specification for Smoked Turkey Ham dated April 1999 may be used. If the ingredients statement, smoke ingredients, labeling of smoke ingredients, or nutrition facts panel changes from that printed on existing supplies, the contractor/processor must request temporary approval for use of carryover inventories from FSIS.

Shipping containers or labels with incorrect: (1) contract number, (2) plant number, (3) net weight, (4) date packed, (5) name of product, (6) qualifying statement, (7) ingredients statement, or (8) nutrition facts information or panel must be corrected before they are used. The incorrect information must be blocked out and the correct information legibly printed, stamped, or stenciled in permanent ink. Additionally, the name, address, and phone number of the manufacturer must appear on each shipping container.

E. Commercial Labeling Requirements

Commercially labeled packages and shipping containers must be labeled in accordance with FSIS requirements. Labeling must be approved by FSIS prior to acceptance for use under this Specification.

1. Distributor Labels. Commercial labels must be the manufacturer's own commercial label. Distributors' labels will not be allowed.

2. Traceable Product.

a. The manufacturer must establish a product identification and record system that clearly links product by place and time of manufacture to specific USDA contracts and destinations. When the company uses the same commercial label for the product certified as complying with this Specification and commercial product, the identification system must differentiate between USDA and non-USDA products. An alpha numeric code may be used for information that is in addition to FSIS labeling requirements.

b. The required product identification and record system, including codes, must be reviewed by USDA before production begins for the contract(s). The USDA grader will include the product identification code on the USDA Poultry Grading Certificate that will accompany the product to destination.

F. Additional Labeling Issues

The following will not be accepted for use under this Specification:

-- Commercial labels that do not have a manufacturer traceability system and code are not allowed.

-- Commercial labeling traceability coding and systems that have not been reviewed by a representative of Poultry Programs, Grading Branch are not allowed.

-- Distributor commercial labels are not allowed.

-- Two or more different commercial labels are not allowed in the same purchase unit.

-- Commercial labels and USDA labels are not allowed in the same purchase unit.

III.

G. F.a.s. Vessel Deliveries

F.a.s. vessel deliveries that are not source loaded in a seavan are required to show the final destination's overseas address as provided in the Notice to Deliver. The address must be clearly printed on at least two sides of each pallet.

IV. FINAL EXAMINATION OF PACKAGED AND PACKED COMMODITY

A. Material and Net Weight Compliance

1. Verification of Materials and Defects.

a. Verification of packaging and packing materials. The contractor must verify compliance with packaging, packing, and marking material requirements by furnishing the USDA grader the following certification on company stationery signed by a person authorized to do so by the contractor:

“(I)(We) certify that the packaging, packing, and marking materials used for any commodity presented for acceptance under the terms of this Commodity Specification for Smoked Turkey Hams dated May 2002, comply or will comply with the terms of this Commodity Specification.

Name _____

Title _____”

One certification is adequate for all production under this Specification.

b. Packaging defects. Packages in a delivery unit will be examined for defects that affect protection, expose product, or permit dehydration or freezer burn, or quality deterioration during storage, such as tears, holes, or improperly sealed packages.

c. Packing defects. Shipping containers in a delivery unit will be examined for condition, labeling, and marking defects according to the United States Standards for Condition of Food Containers.

d. Tolerance for defects. If samples of packaged commodity or the shipping containers in a delivery unit have more defects than the maximum tolerance for the applicable Poultry Programs' sample plan, the delivery unit will be rejected.

2. Net Weight. A purchase or delivery unit must total 40,000 pounds (18,144 kg) net, or multiples thereof.

a. Test weighing procedures.

(1) The tare weight of all packing materials will be determined by weighing a representative sample of all packaging components such as plastic-film bags, clips, and fiberboard containers.

(2) A representative sample will be selected in accordance with the following sample plan:

<u>Number of Shipping Containers in Lot</u>	<u>Number of Shipping Containers in a Sample</u>
1 - 4	All
5 - 50	4
51 - 100	5
101 - 200	6
201 - 400	7
401 - 600	8

For each additional 100 cases, or fraction thereof, in excess of 600 cases, one additional case shall be included in the sample.

c. Weight variations. A weight variation of plus or minus 1 percent (39,600 to 40,400 pounds (17,962 to 18,325 kg)) is permitted on each delivery unit. USDA will pay the contractor only for the amount of commodity delivered within the required weight range. Any delivery unit weighing less than 39,600 pounds (17,962 kg) net will be rejected. Net weight for hams will be determined at origin. The net weight of each delivery unit will be determined by a USDA grader at the contractor's expense at the destination.

b. Alternate net weight verification. As an alternative to test weighing at time of loading, the contractor may request on-line verification of net weights. Upon receiving the request, a Federal-State supervisor, Grading Branch, Poultry Programs will determine that the facilities and procedures are in accordance with the applicable Poultry Programs' instructions for this Specification.

B. Prerequisites for Loading and Shipping Frozen Commodity

1. Visual Inspection. Frozen commodity showing any evidence of thawing, refreezing, or freezer deterioration will be rejected for use under this Specification.

2. Internal Product Temperature.

a. Requirements. The internal product temperature of frozen commodity must be 2 EF (-16.7 EC) or lower at time of loading. Delivery units with internal product temperatures exceeding 2 EF (-16.7 EC) and up to 5 EF (-15 EC) will be tentatively rejected.

IV.B.2.

Tentatively rejected delivery units may be returned to the freezer and the temperature reduced to 2 EF (-16.7 EC) or lower and reoffered one time only. Delivery units exceeding 5 EF (-15 EC) or delivery units that have been tentatively rejected and exceed 2 EF (-16.7 EC) when reoffered will be rejected.

b. Optional temperature verification. As an option to verifying internal product temperature at time of loading, the contractor may request an alternate method utilizing product temperature sensing devices. If this option is selected, a Federal-State supervisor will determine that the facilities, equipment, procedures, and the contractors' current level of freezing compliance are in accordance with the established guidelines outlined in the applicable Poultry Programs' instructions for this Specification.

C. Inspection and Checkloading

1. Requirements. Inspection for contract compliance will be made by a USDA representative, in accordance with 7 C.F.R. part 70, FSIS regulations, and this Specification, at site of processing, both during and after processing and packaging. A USDA representative may select samples or inspect the commodity at any point in transit and after delivery to point of destination. Inspection records must be complete and made available to USDA, as requested, to assure contract compliance.

2. Procedures. The inspection and checkloading required by Articles 54 and 55 of USDA-1 must be performed by the USDA grader. Procedures to be followed and a schedule of fees for these services may be obtained by contacting the nearest Grading Branch field office or the Chief of Grading Branch, Poultry Programs, AMS, USDA, Room 3938-S, STOP 0258, 1400 Independence Avenue, SW, Washington, D.C. 20250-0258, telephone (202) 720-3271. The quality, quantity, weight, packaging, packing, and checkloading of the commodity must be evidenced by certificates issued by the USDA grader. Contractor must not ship the commodity unless informed by the USDA grader that the designated commodity to be shipped meets contract specifications.

V. UNITIZATION

Each delivery unit of smoked turkey hams must be unitized (palletized and stretchwrapped) and comply with the following:

A. Pallets

Pallets must be good quality, wood, 48 inches x 40 inches, nonreversible, flush stringer, and partial fourway entry. Each pallet of shipping containers must be stretchwrapped with plastic film in a manner that will secure each container and layer of containers on the pallet. Palletized product must be loaded in a way that will prevent shifting and damage to the containers of product.

B. Pallet Exchange

Contractors may arrange for pallet exchange with consignees; however, USDA is in no way responsible for such arrangements.

VI. SHIPMENT AND DELIVERY

Shipment and delivery must be made in accordance with this Specification, the applicable Announcement and Invitation, and Articles 56, 57, and 64 of USDA-1, as amended by the Announcement. In addition, the following provisions must be adhered to:

A. Contract Compliance Stamp

Each shipping container must be identified with a USDA Contract Compliance stamp with the applicable certificate number. A USDA grader, or other authorized personnel under the supervision of the USDA grader, will stamp one end of each shipping container prior to shipment. If there is inadequate space available on either end of the shipping container, the stamp may be applied to a side of the container.

B. Grading Certificate

A copy of the original USDA Poultry Products Grading Certificate issued at time of checkloading must accompany each shipment.

1. Railcar or Piggyback. If shipment is by rail or piggyback, the certificate must be placed in the railcar or trailer for easy access to the USDA grader, warehouseman, or consignee, as applicable.

2. Trucks. If shipment is by truck, the driver must, upon delivery, give the certificate to the USDA grader, warehouseman, or consignee, as applicable.

C. Loading and Sealing of Vehicles

Loading must be in accordance with good commercial practices and the sealing must be done at origin under the supervision of a USDA grader.

1. Railcar. Each railcar must be sealed. The contractors are responsible for arranging railcar deliveries of more than one delivery unit so that each delivery unit contained in the same railcar can be completely separated and sealed.

2. Truck or Piggyback. Truck or piggyback shipments must be sealed at origin. A delivery unit shipped by truck or piggyback which includes split deliveries to multiple destinations will not require separation by sealing each drop.

VI.

D. Delivery Notification

Notwithstanding the provisions of Article 56(c) of USDA-1, as amended by the applicable Announcement, the contractor must follow the instructions in the Notice to Deliver issued by the Kansas City Commodity Office (KCCO) concerning delivery notification. Such notification and information of impending delivery are vital in proper execution of delivery. The contractor must notify the State distributing agency and the consignee of shipment per instructions in the Notice to Deliver. For rail or piggyback shipments, notification shall be made on the day of shipment. For truck shipments, notification of the estimated arrival time should be made as far in advance of delivery as possible. In addition, for truck or piggyback shipments, the contractor must request and keep scheduled appointment(s). Unloading appointments for truck or piggyback shipments must be requested from the consignee contact party(ies) at least 24 hours in advance of delivery.

1. In-Plant Deliveries. When in-plant delivery is made, the contractor must notify the appropriate USDA resident grader and furnish applicable information.

2. Delivery In Storage. Delivery may be made in store provided the destination in the Notice to Deliver and the place the contractor has the commodity in storage are the same. Inspection and certification by a USDA grader are also required for transfers in store.

3. Early Delivery. The contractor may deliver early upon approval of the KCCO. Approval may be obtained by telephoning (816) 926-6068. Approval is contingent on the recipient's concurrence to accept early delivery and upon the USDA grader being available to perform necessary checkloading and final acceptance duties.

E. Split Deliveries

The contractor is responsible to deliver the quantity stated on each Notice to Deliver to each destination. Contractors must provide to the USDA Grader, at time of shipment, the number of boxes and pounds for each destination. At the option of the contractor, a purchase unit with two or more Notices to Deliver (split deliveries) for multiple destinations may be delivered on separate trucks provided each truck ships the total quantity stated on the Notice to Deliver. Any additional costs will accrue to the **contractor's** account.

VII. DESTINATION EXAMINATION

The cost of a destination examination, before or after delivery, by a USDA grader on accepted product will be for the account of USDA. Costs for destination examinations of rejected delivery units will be for the account of the contractor. The USDA origin grader will make arrangements for destination examination prior to delivery.


A. Commodity Requirements

Before acceptance by consignee, the commodity may be examined by a USDA grader on a spot-check basis for temperature, condition, identity, and when applicable, count. The commodity may be examined for conformance to contract provisions at any time required by the Contracting Officer.

B. Temperature

The commodity must arrive at destination at an average internal product temperature not to exceed 10 °F (-12.2 °C) with no individual temperature exceeding 15 °F (-9.4 °C).

Commodity not meeting these requirements will be rejected for use under this Specification.

A handwritten signature in blue ink, reading "Howard M. Magwire", is positioned above a horizontal line.

Howard M. Magwire
Deputy Administrator, Poultry Programs

Attachment

EXHIBIT 1

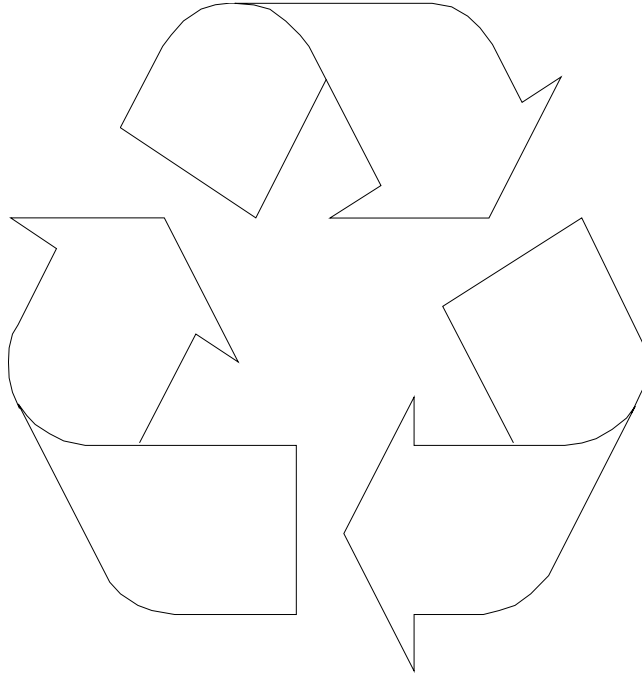
Example Formulation For Smoked Turkey Hams

In the formulation of turkey hams, the meat/ingredient portion and the added water portion are considered two separate components. The meat/ingredient portion is cited in section II.C.4. on page 7 of this Specification. Water/ice must be added to the meat/ingredient portion to assist in the processing of turkey hams and may be added in an amount to be determined by the contractor/processor taking into consideration the smoking/cooking method and yield. The end product must comply with the 15 percent water added requirement and this Specification. The formulation below is only an example and should not be mistaken for actual poundage to be used.

	<u>Number of Pounds</u>
Size-Reduced Turkey Thigh Meat (may contain up to 15% thigh trimmings)	95.45
Salt	2.00
Brown Sugar	2.00
Sodium Phosphate	0.50
Sodium Erythorbate	0.04
Sodium Nitrite	<u>0.01</u>
Raw Weight w/o Water	100.00 lbs.
Water/Ice	<u>43.75</u>
Raw Batch Weight	143.75 lbs
Finished Weight	<u>x 0.80</u> *
	115.00 lbs.

* Percent yield after smoking/cooking.

EXHIBIT 2
“Please Recycle” Symbol and Statement



**PLEASE
RECYCLE**

EXHIBIT 3 USDA Labeled Shipping Containers

Marking Information: Shipping containers may be marked substantially as shown below. Detailed USDA labeling information is provided in Exhibits 4 and 5. Markings must be preprinted, stamped, stenciled on containers, or printed on a separate pressure-sensitive label and applied to containers. The USDA symbol is to be a minimum of 2.25 inches (5.72 cm) in height and may be printed on the “TOP PANEL” or “ONE END” designated panel. The manufacturer’s name, address, and phone number may be printed on the “TOP PANEL” or “ONE END” designated panel.

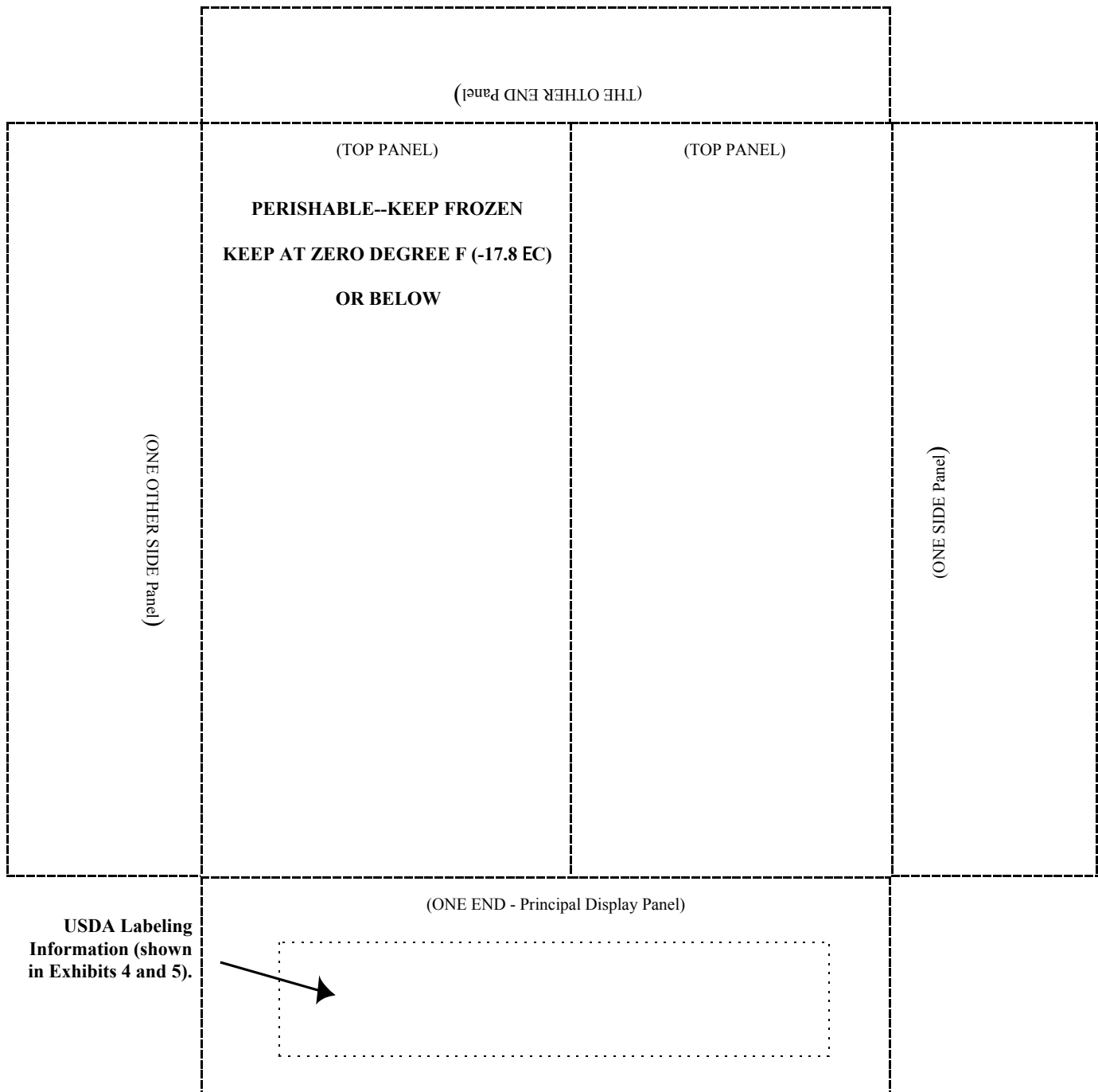


EXHIBIT 4
USDA Label Information
For Commodity Smoked In Accordance With II.C.7.b.(1) (page 9)

Marking Information: USDA labeling information must be printed on the "ONE END" panel of each shipping container as provided in Exhibit 3. Markings must be preprinted, stamped, stenciled on containers, or printed on a separate pressure-sensitive label and applied to containers. The UPC 14-digit I 2/5 code (1 07 15001 01548 5), bar and code, must be shown in the lower right-hand corner of the "ONE END" designated panel. The USDA symbol must be a minimum of 2.25 inches (5.72 cm) in height and may be printed on the "TOP PANEL" or "ONE END" designated panel. The manufacturer's name, address, and phone number may be printed on the "TOP PANEL" or "ONE END" designated panel.



**FROZEN FULLY COOKED
SMOKED TURKEY HAM***
with 15% Water



*Cured Turkey Thigh Meat, Chunked and Formed
95% FAT FREE

Ingredients:

**Manufacturer's
Name, Address, and Phone**

**Nutrition Facts Panel
May Be Placed Here**

KEEP FROZEN

___ **Bags Net Weight**
___ **LBS. (___ KG)**

CONTRACT NO. _____
DATE PACKED Month, Day, and Year

UPC Bar and Code

EXHIBIT 5
USDA Label Information
For Commodity Smoked In Accordance With II.C.7.b.(2) (page 9)

Marking Information: USDA labeling information must be printed on the “ONE END” panel of each shipping container as provided in Exhibit 3. Markings must be preprinted, stamped, stenciled on containers, or printed on a separate pressure-sensitive label and applied to containers. The UPC 14-digit I 2/5 code (1 07 15001 01548 5), bar and code, must be shown in the lower right-hand corner of the “ONE END” designated panel. The USDA symbol must be a minimum of 2.25 inches (5.72 cm) in height and may be printed on the “TOP PANEL” or “ONE END” designated panel. The manufacturer’s name, address, and phone number may be printed on the “TOP PANEL” or “ONE END” designated panel.



**FROZEN FULLY COOKED
SMOKED TURKEY HAM***
with 15% Water



*Cured Turkey Thigh Meat, Chunked and Formed,
Smoke Flavor Added 95% FAT FREE

Ingredients:

**Manufacturer’s
Name, Address, and Phone**

**Nutrition Facts Panel
May Be Placed Here**

KEEP FROZEN

__ **Bags Net Weight**
__ **LBS. (__ KG)**

CONTRACT NO. _____
DATE PACKED Month, Day, and Year

UPC Bar and Code

USDA SYMBOL

